

Line for production of welded upright profile for supermarket with H.F. welding

MACHINES

LINE FOR WELDED SUPERMARKET UPRIGHT

- 54002    **1 DECOILERS**  
*Decoilers from 2 up to 30 tonnes.*

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- 9001A    **2 STRAIGHTENER**  
*N° 2 feeder rolls - n° 7 straightening rolls*

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- 3R        **3 HEADING AND WELDING BENCH**

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- 10002A    **4 FEEDER WITH ROLLS**  
*N° 2 tempered and rectified rolls – brushless motor – encoder group.*

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- 2Z        **5 MECHANICAL PRESS 100 t**

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- 194B     **6 PUNCHING DIE WITH EXCLUSIONS**

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- 240.80A    **7 ROLL FORMING LINE PME TYPE**  
*Shaft Ø 80 mm, passages 16+2*

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- 329A     **8 WELDING HEAD WITH H.F. WELDER**  
*Welding head with welder H.F.*

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- 318       **9 TUBE COOLING PLANT**

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- 11C       **10 ROLL FORMING LINE PME TYPE F.CALIBRATION**  
*Roll forming line PME type for tube calibration*

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- 11G       **11 HYDRAULIC FLYING CUTTING PRESS**

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- 12H       **12 UNLOADING AND STACKING BENCH**

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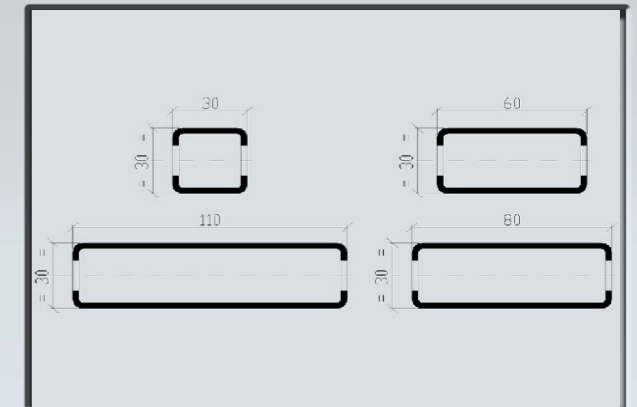
- 251-252    **13 CONTROL DESK W. ELECTRICAL INSTALLATION**



View of the line



Finished product



Section of products



50102C

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## LINE FOR WELDED SUPERMARKET UPRIGHT

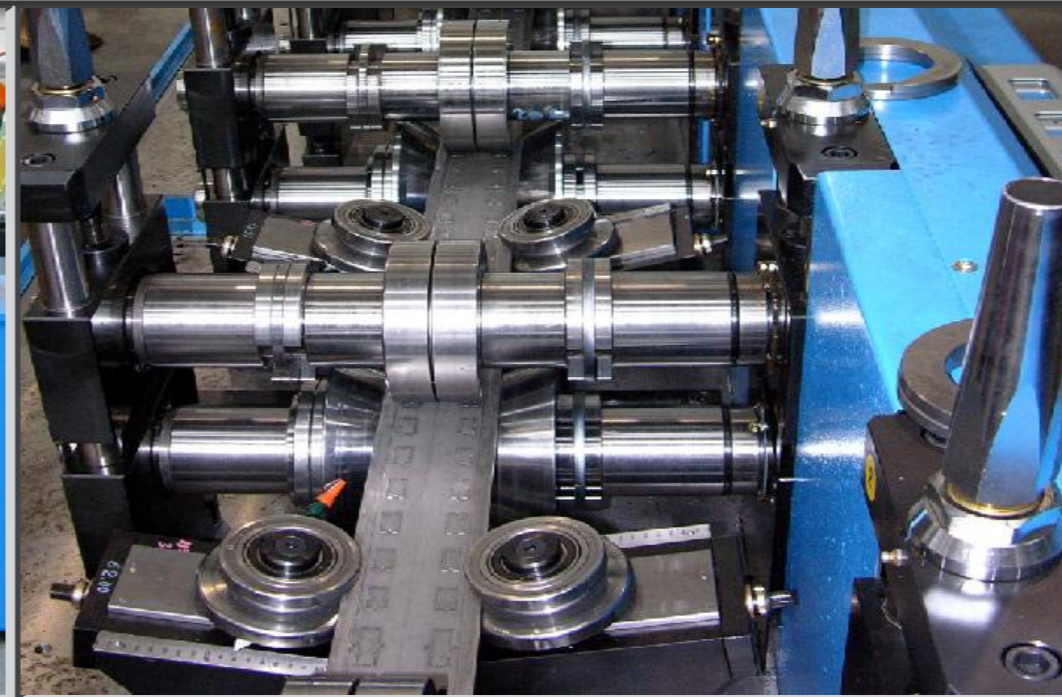
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Automatic line for punching (punching before profiling), welding, calibrating, cutting and unloading. This innovative solution allows, in respect of the punching of the tube executed after profiling, to be more automated, faster, more flexible and with less scrap. Practically the production cost is lower as regards the punching of the traditional tube.

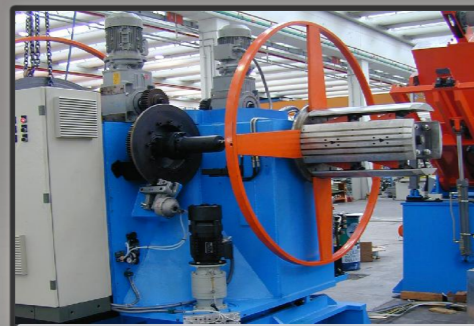


Heading and welding bench

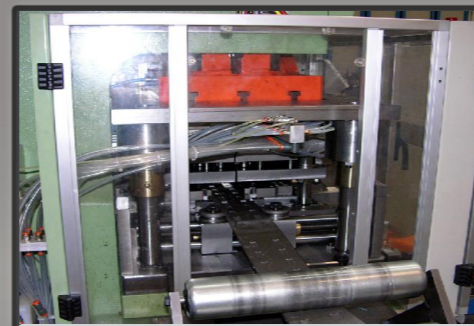


Detail roll forming line

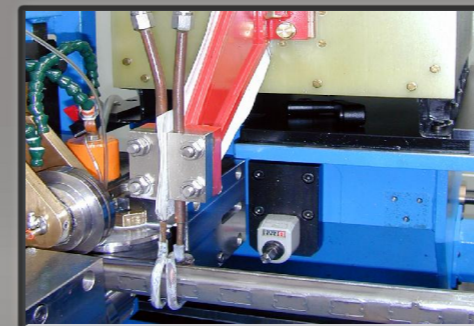
Useful width:	300	mm
Material for upright: Fe		
Thickness	2,5	mm
Decoiler capacity	5+5	t
Line speed	~10	m/min.
Line direction: from right to left		
Installed power:	270	Kw
Air consumption:	2900	NI/1



Double pivoting decoiler



Die detail of press



Detail welding head



Detail cutting die

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